

Date: Thursday, 04/09/2008 1:23:04 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 41822		
Estimate Number	: 10615		
P.O. Number	:	Part Number	: D265623
This Issue	: 04/09/2008 S.O. No. :	Drawing Number	: D2656 REV D
Prsht Rev.	: NC	Project Number	: N/A
File Issue	: // Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 34597	Material	:
Written By	:	Due Date	: 06/10/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>JUL 08.9.04</u>		
Comment	: Est: D 02.10.25 Re-format KJ		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025 SHEET
-----	------------	-----------------



Comment: Qty.: 1.4800 sf(s)/Unit Total : 17.7597 sf(s)

1018.20 GA .040" THK

Batch: 108275 B 8-9-15

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D2656

Dwg Rev: DProg Rev: D

2-Deburr if necessary

B 8-9-15B 8-9-15

(13)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 08/09/16 (13)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D2656 using Jig DT8158

3-Identify as D2656-23

S 08/09/18 (13)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

Date: Thursday, 04/09/2008 1:23:04 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 41822

Part Number: D265623

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/18 (X13)

7.0

POWDER COATING

POWDER COATING



M106442



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

1:00pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

1:30pm

HD 08-09-18 X13

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/09/18 (13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F-P 21

M-L 08/09/18

(13X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/19

Job Completion



MF 08-09-19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41822
<b>Description:</b> Wearshoe		<b>Part Number:</b> D2656-23
<b>Inspection Dwg:</b> D2656	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

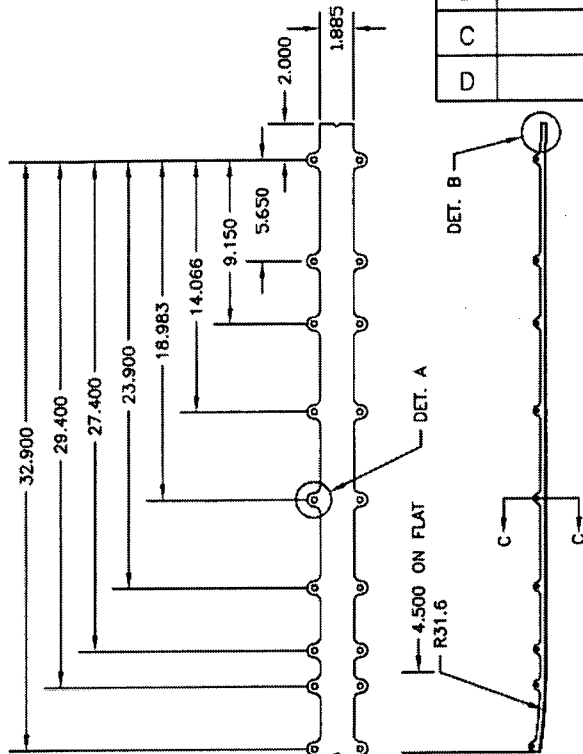
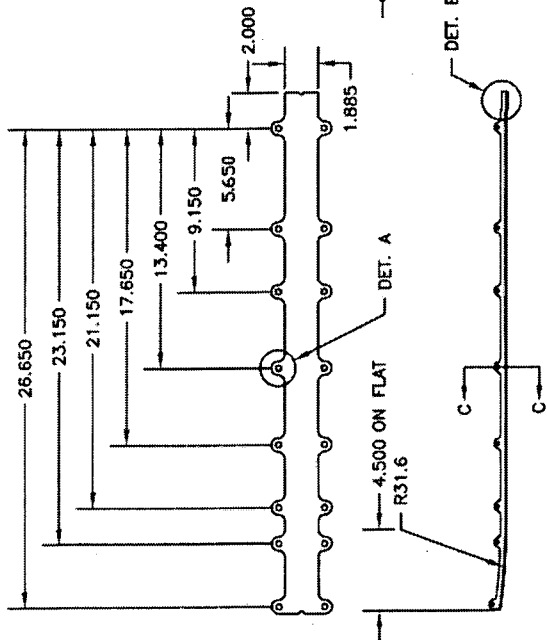
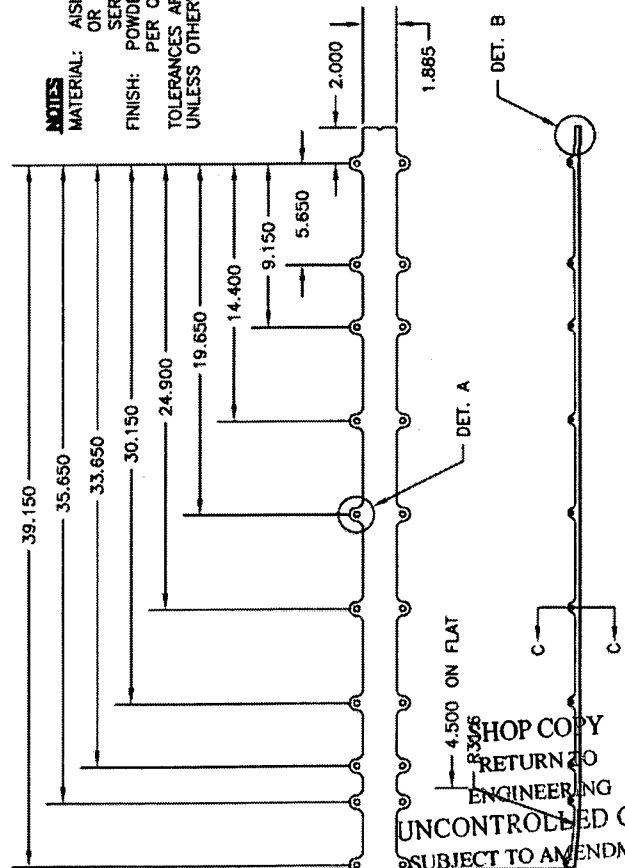
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.850	+/-0.010	52.850	X			
48.200	+/-0.010	48.200	X			
44.700	+/-0.010	44.700	X			
39.310	+/-0.010	39.310	X			
33.920	+/-0.010	33.920	X			
28.530	+/-0.010	28.530	X			
23.140	+/-0.010	23.140	X			
17.750	+/-0.010	17.750	X			
14.250	+/-0.010	14.250	X			
9.500	+/-0.010	9.500	X			
4.750	+/-0.010	4.750	X			
2.000	+/-0.010	2.000	X			
2.000	+/-0.010	2.001	X			
1.885	+/-0.010	1.887	X			
0.300	+/-0.010	.301	X			
0.300	+/-0.010	.302	X			
0.040	+/-0.010	.039	X			

<b>Measured by:</b> JB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-9-15	<b>Date:</b> 08/09/16	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	BE

**DART**

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				D2656	SHEET 1 OF 4
DATE				TITLE	SCALE
05.08.17				WEARSHOE	1:10
A	97:03:25	NEW ISSUE			
B	97:06:02	CHANGED TABS			
C	97:06:26	R31.6 WAS R19.5			
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT			

**D2656-13****D2656-11****D2656-15****NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDETEX (4.3.5.6)  
PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

RELEASED  
05-09-08

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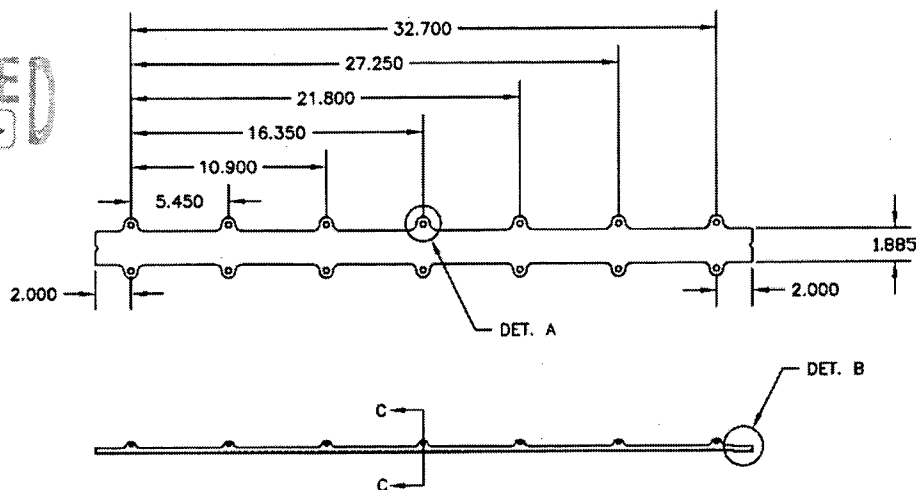
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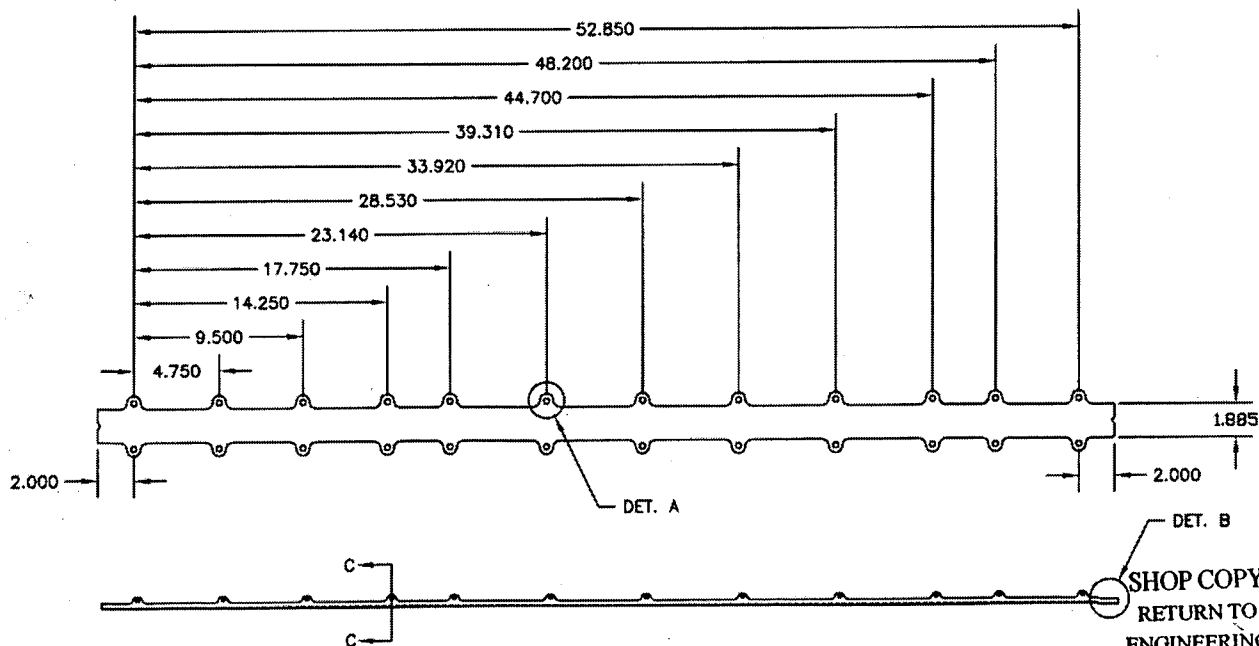
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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### D2656-21



### D2656-23



#### NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
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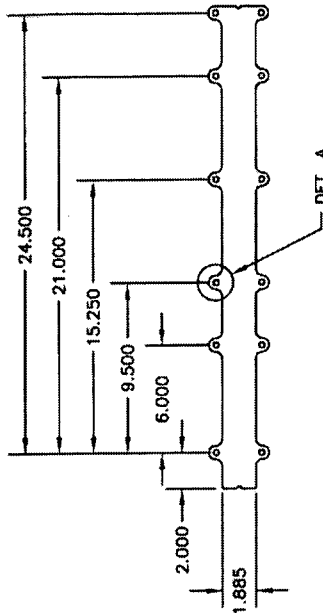
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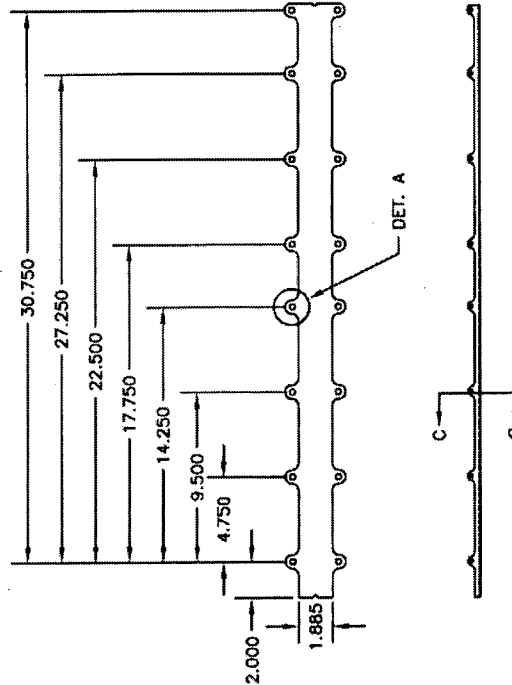


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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

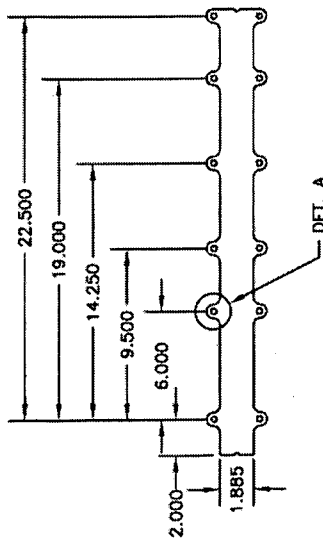
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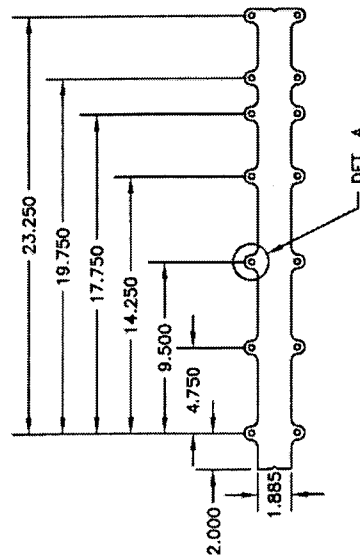
D2656-37



D2656-31



D2656-35



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TOLERANCES ARE PER DART QSI 018  
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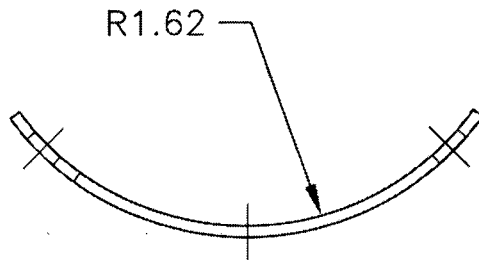
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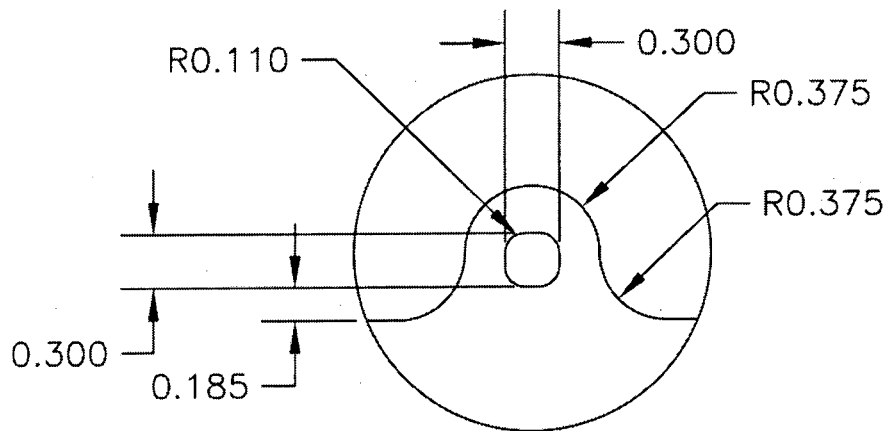
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				D2656	SHEET 4 OF 4
DATE	05.08.17			TITLE	SCALE
				WEARSHOE	1:10

### SECTION C-C

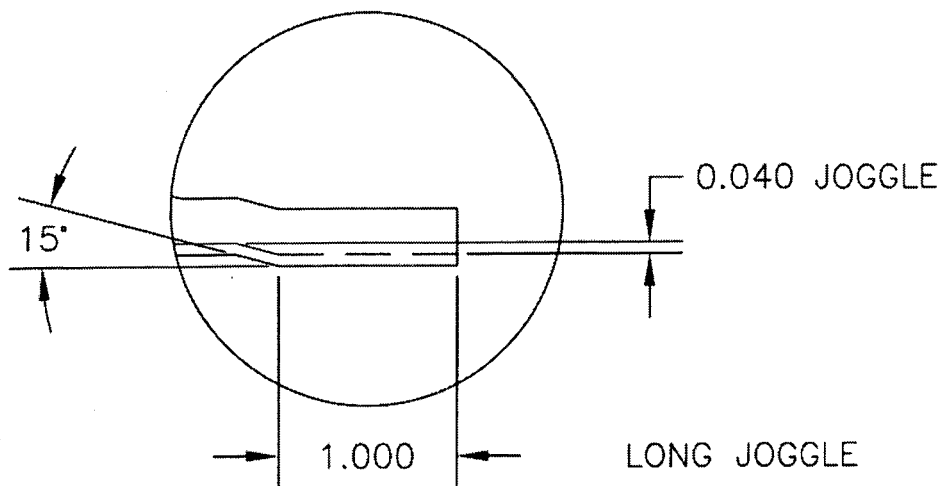


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### DETAIL A



### DETAIL B



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